Section 1. Registration Information

Source Identification

Facility Name:	Farmer John Meats
Parent Company #1 Name:	Hormel Foods Corporation
Parent Company #2 Name:	

Submission and Acceptance

Submission Type:	Correction or administrative change
Subsequent RMP Submission Reason:	Notification of facility ownership change
Description:	Re-submittal Oct 2005
Receipt Date:	08-Nov-2005
Postmark Date:	07-Nov-2005
Next Due Date:	20-Dec-2009
Completeness Check Date:	29-Jul-2008
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	Yes

Facility Identification

EPA Facility Identifier:	1000 0013 3125
Other EPA Systems Facility ID:	CAD 981653728
Facility Registry System ID:	1100 0049 7917

Dun and Bradstreet Numbers (DUNS)

Facility DUNS:	
Parent Company #1 DUNS:	6147383
Parent Company #2 DUNS:	

Facility Location Address

Street 1:	3049 East Vernon Avenue
Street 2:	
City:	Vernon
State:	CALIFORNIA
ZIP:	90058
ZIP4:	0870
County:	LOS ANGELES

Facility Latitude and Longitude

Latitude (decimal):	34.006652
Longitude (decimal):	-118.217422
Lat/Long Method:	Interpolation - Digital map source (TIGER)
Lat/Long Description:	Center of Facility
Horizontal Accuracy Measure:	100
Horizontal Reference Datum Name:	North American Datum of 1983
Source Map Scale Number:	

Owner or Operator

Operator Name:	Farmer John Meats
Operator Phone:	(323) 583-4621

Mailing Address

Operator Street 1:	3049 East Vernon Avenue
Operator Street 2:	
Operator City:	Vernon
Operator State:	CALIFORNIA
Operator ZIP:	90058
Operator ZIP4:	0870
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:	Alex Byk
RMP Title of Person or Position:	Engineering Supervisor
RMP E-mail Address:	abyk@farmerjohn.com

Emergency Contact

Emergency Contact Name:	Larry Rehaume
Emergency Contact Title:	Plant Engineer
Emergency Contact Phone:	(323) 583-4621
Emergency Contact 24-Hour Phone:	(323) 312-8401
Emergency Contact Ext. or PIN:	385
Emergency Contact E-mail Address:	lmrehaume@hormel.com

Other Points of Contact

Facility or Parent Company E-mail Address:	
Facility Public Contact Phone:	
Facility or Parent Company WWW Homepage Address:	www.farmerjohn.com

Local Emergency Planning Committee

LEPC:	California Region 1 LEPC

Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:	1540
FTE Claimed as CBI:	

Covered By

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	

Air Operating Permit ID:

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency) Date:	20-Apr-2004
Last Safety Inspection Performed By an External Agency:	Fire Department

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name:	Manthe & Associates
Preparer Phone:	(763) 475-1138
Preparer Street 1:	3010 Alvarado Lane N
Preparer Street 2:	
Preparer City:	Plymoouth
Preparer State:	MINNESOTA
Preparer ZIP:	55447
Preparer ZIP4:	
Preparer Foreign State:	
Preparer Foreign Country:	
Preparer Foreign ZIP:	

Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents: See Section 6. Accident History below to determine if there were any accidents reported for this RMP.

Process Chemicals

Process ID:	63776
Description:	
Process Chemical ID:	84368
Program Level:	Program Level 3 process
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Quantity (lbs):	110000
CBI Claimed:	
Flammable/Toxic:	Toxic

Process NAICS

Process ID:	63776
Process NAICS ID:	65283
Program Level:	Program Level 3 process
NAICS Code:	31161
NAICS Description:	Animal Slaughtering and Processing

Section 2. Toxics: Worst Case

Toxic Worst ID: 42033

Percent Weight:	
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP Guidance for Ammonia Refrigeration Reference Tables or Equations
Release Duration (mins):	10
Wind Speed (m/sec):	1.5
Atmospheric Stability Class:	F
Topography:	Urban

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Section 3. Toxics: Alternative Release

Toxic Alter ID: 49569

Percent Weight:	
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP Guidance for Ammonia Refrigeration Reference Tables or Equations
Wind Speed (m/sec):	3.0
Atmospheric Stability Class:	D
Topography:	Urban

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Active Mitigation Considered

Sprinkler System:	
Deluge System:	
Water Curtain:	
Neutralization:	
Excess Flow Valve:	
Flares:	
Scrubbers:	
Emergency Shutdown:	
Other Type:	Emergency Response

Section 4. Flammables: Worst Case

No records found.

Section 5. Flammables: Alternative Release

No records found.

Section 6. Accident History

No records found.

Section 7. Program Level 3

Description

No description available.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	54237
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7
Process ID:	63776
Description:	
Prevention Program Level 3 ID:	37318
NAICS Code:	31161

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	16-Nov-2004

Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	03-Sep-2004

The Technique Used

What If:	
Checklist:	Yes
What If/Checklist:	
HAZOP:	Yes
Failure Mode and Effects Analysis:	
Fault Tree Analysis:	
Other Technique Used:	Site Inspection
PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):	30-Sep-2005

Major Hazards Identified

Toxic Release:	Yes
Fire:	Yes
Explosion:	Yes
Runaway Reaction:	
Polymerization:	
Overpressurization:	Yes
Corrosion:	Yes
Overfilling:	Yes
Contamination:	Yes
Equipment Failure:	Yes
Loss of Cooling, Heating, Electricity, Instrument Air:	

Earthquake:	Yes
Floods (Flood Plain):	
Tornado:	
Hurricanes:	
Other Major Hazard Identified:	

Process Controls in Use

Vents:	
Relief Valves:	Yes
Check Valves:	Yes
Scrubbers:	
Flares:	
Manual Shutoffs:	Yes
Automatic Shutoffs:	Yes
Interlocks:	Yes
Alarms and Procedures:	Yes
Keyed Bypass:	
Emergency Air Supply:	
Emergency Power:	
Backup Pump:	Yes
Grounding Equipment:	
Inhibitor Addition:	
Rupture Disks:	
Excess Flow Device:	
Quench System:	
Purge System:	
None:	
Other Process Control in Use:	Auto Purger

Mitigation Systems in Use

Sprinkler System:	Yes
Dikes:	
Fire Walls:	
Blast Walls:	
Deluge System:	
Water Curtain:	
Enclosure:	Yes
Neutralization:	
None:	
Other Mitigation System in Use:	

Monitoring/Detection Systems in Use

Process Area Detectors:	Yes
Perimeter Monitors:	
None:	
Other Monitoring/Detection System in Use:	

Changes Since Last PHA Update

Reduction in Chemical Inventory:	
Increase in Chemical Inventory:	Yes
Change Process Parameters:	

Installation of Process Controls:	Yes
Installation of Process Detection Systems:	Yes
Installation of Perimeter Monitoring Systems:	
Installation of Mitigation Systems:	
None Recommended:	
None:	
Other Changes Since Last PHA or PHA Update:	

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures):	01-Nov-2004

Training

Training Revision Date (The date of the most recent review or revision of training programs):	24-Sep-2004

The Type of Training Provided

Classroom:	
On the Job:	Yes
Other Training:	

The Type of Competency Testing Used

Written Tests:	
Oral Tests:	
Demonstration:	Yes
Observation:	Yes
Other Type of Competency Testing Used:	

Maintenance

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures):	08-Oct-2004
Equipment Inspection Date (The date of the most recent equipment inspection or test):	17-Jan-2004
Equipment Tested (Equipment most recently inspected or tested):	South Engine Room Frick Compressor #2

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):	
Change Management Revision Date (The date of the most recent review or revision of management of change procedures):	09-Aug-2004

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):	

Compliance Audits

Compliance Audit Date (The date of the most recent compliance audit):	
Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit):	

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):	
Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):	

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans):	24-Sep-2004

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures):	09-Aug-2004

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures):	09-Aug-2004
Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):	09-Aug-2004

Confidential Business Information

CBI Claimed:	

Section 8. Program Level 2

No records found.

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?):	Yes
Facility Plan (Does facility have its own written emergency response plan?):	Yes
Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?):	Yes
Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?):	Yes
Healthcare (Does facility's ER plan include information on emergency health care?):	Yes

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan):	18-Nov-2004

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees):	07-Dec-2004

Local Agency

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated):	Fire Department / City of Vernon
Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated):	(626) 583-4821

Subject to

OSHA Regulations at 29 CFR 1910.38:	Yes
OSHA Regulations at 29 CFR 1910.120:	Yes
Clean Water Regulations at 40 CFR 112:	
RCRA Regulations at CFR 264, 265, and 279.52:	
OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:	
State EPCRA Rules or Laws:	Yes
Other (Specify):	

Executive Summary

ACCIDENTAL RELEASE PREVENTION AND EMERGENCY RESPONSE POLICIES

The Farmer John facility located in Vernon, California, utilizes anhydrous ammonia to provide refrigeration for processing areas and cold / freezer storage rooms. Senior management at Farmer John is committed to maintain a safety and environmental program to promote a safe environment for all its employees and the surrounding communities. Senior management as well as the Safety Director administers the facility's safety and environmental policies and programs. These programs include but are not limited to forklift safety, hazard communications, lockout/tagout, Hazardous Materials Emergency Business Plan, employee safety manuals, manufacturer¿s documentation, Emergency Response, as well as the Risk Management Plan.

Farmer John has an emergency response team in place that has coordinated their emergency response efforts with the local City of Vernon Fire Department. In the case of an ammonia-related emergency, it is the policy of Farmer John to evacuate the employees and to allow the HazMat team / fire department respond to the emergency.

The majority of the ammonia equipment is located inside the engine rooms. However process rooms and cold / freezer storage rooms do have small flooded accumulator / evaporator units and piping. There are no emissions or planned releases of ammonia.

STATIONARY SOURCE AND REGULATED SUBSTANCE

The Farmer John facility is located at 3049 East Vernon Avenue in Vernon, California. The facility is situated directly south of the Los Angeles River / Channel and approximately 1.1 miles southwest of Interstate 5. The area immediately surrounding the facility is urban, comprised of a mixture of commercial, industrial, and residential areas.

Anhydrous Ammonia System

Refrigeration at Farmer John is achieved via three anhydrous ammonia refrigeration systems which are titled the North, Plant, and Soft Chill Systems. The North and Plant Systems are interconnected via one normally closed liquid line which is opened only in the rare event that ammonia must be transferred quickly from the North to South Engine Room. Also, occasionally the Soft Chill and Plant Systems are interconnected via the Pump-out Compressor. The Pump-out Compressor is set to pull suction from either the Plant or Soft Chill System (only one system at a time). Two bolted flanges keep the suction line `switch-over' pipe securely fastened to one of the two systems. The compressor's discharge line is normally connected to the Plant System's Intermediate Pressure Accumulator / Intercooler but can be setup to send ammonia vapor to the Soft Chill System's compressor suction line or send ammonia to the Water Diffusion Tank (again via a switch-over pipe).

The ammonia refrigeration systems are closed systems that transform the refrigerant, ammonia, from liquid to gas and back to a liquid. The systems, consisting of vessels, piping, valves, and process equipment, transform ammonia through various cyclical physical states (high pressure liquid, low pressure liquid, low pressure vapor, high pressure vapor, then back to high pressure liquid) in order to provide refrigeration for processing areas and cold / freezer storage rooms.

Changes in pressure are directly related to changes in temperature: lowering the ammonia pressure lowers its temperature as portions of the liquid flash to vapor. Low pressure (cold) liquid ammonia provides refrigeration by removing ambient heat. Removal of ambient heat causes the liquid ammonia (contained within the system) to vaporize. Heat is later removed from the ammonia as it is condensed back into a liquid.

Farmer John refrigeration personnel estimate the facility's total ammonia inventory at 110,000 pounds: 30,000 pounds within the Soft Chill System, 50,000 pounds within the North System, and 30,000 pounds within the Plant System.

RISK MANAGEMENT PROGRAM AND CHEMICAL-SPECIFIC PREVENTION STEPS

Anhydrous Ammonia

The Farmer John ammonia refrigeration system has many safety features. Much of the safety of the system is inherent in the policies and procedures that govern the operation of the system. For example, the facility operates in accordance with OSHA's

Process Safety Management regulation, the California Accidental Release Prevention (CalARP) program and EPA's Risk Management Program (RMP). Operating Engineerings, knowledgeable persons in the ammonia refrigeration industry, work at the facility to regularly maintain the system and perform any repairs.

Ammonia detectors are strategically located in the South Engine Room. If ammonia is detected at a concentration of 250 ppm, audible and visual alarms are triggered inside the room. Upon detection of 25,000 ppm, the detectors will de-energize the south engine room and activate ventilation fans which move the air/ammonia mix through a scrubber located on the roof.

In the event of a power failure, ammonia operations would automatically shut-down (solenoid valves close, compressors shut-down, condenser fans and water pumps shut-down, evaporator fans shut-down, etc.), thereby limiting the possibility of any ammonia releases. The system must be manually restarted following a power outage.

The system also incorporates pressure relief valves. In the event of over-pressurization, vessels will vent to the atmosphere or water diffusion tank (depending on location) via relief lines. This mechanism prevents vessels from rupturing in case they become over pressurized.

Ammonia refrigeration systems do not experience any chemical reactions or internal corrosion. The only composition change that occurs within the systems are phase changes, as ammonia is cycled through various stages of liquid and vapor, similar to a household refrigerator. The refrigeration system is a closed-loop system without any regular emissions or releases. Any leaks are noted and repaired immediately by an Operating Engineer or refrigeration contractor.

In addition to the 1997 Uniform Mechanical Code, the facility will operate in accordance with the International Institute of Ammonia Refrigeration (IIAR) guidelines. In particular, IIAR Bulletin 110, "Startup, Inspection, and Maintenance of Ammonia Refrigeration Systems" is used as a general guide.

FIVE YEAR ACCIDENT HISTORY

An investigation into Farm John's accident history revealed that there has been no facility reportable ammonia releases over the last five years (November 1999 - November 2004).

EMERGENCY RESPONSE PROGRAM

Farmer John has an emergency response plan in effect at the facility, which is detailed in the PSM/RMP documentation. Emergency response activities are also coordinated with the City of Vernon Fire Department. In case of a major ammonia emergency, the facility will initiate internal response procedures and call 9-1-1 to alert the local Police and Fire Departments. Other responders will be called as needed, including the Department of Public Safety Emergency Management Services. If a release exceeds the federal reporting quantity of 100 pounds for ammonia, the National Response Center and the Emergency Spill Report Center will be called.

Farmer John maintains a safety committee whose members are the designated emergency coordinators for the facility. The plan provides the response organization and notification procedures, evacuation routes, ammonia health hazards, and mitigation procedures which will be implemented to respond effectively to emergency situations that may arise at the facility. The plan is reviewed and updated at least once per year. This plan will be reviewed and updated to ensure compliance with the PSM and RMP regulations, as well as to incorporate any facility changes.

Farmer John will be responsible for evacuating and ensuring the safety of its employees.

PLANNED CHANGES TO IMPROVE SAFETY

A Process Hazards Analysis (PHA) was conducted on September 1st through the 3rd, 2004, to address safety issues regarding the ammonia refrigeration system. The PHA reports include results from the following two elements: 1) the Hazard and Operability (HAZOP) study and 2) a Site Inspection. These studies were performed to define potential hazards associated with operational

deviations of the systems. As a result of the studies, a number of recommendations were made, such as procedural changes, ammonia awareness training and some equipment upgrades. These recommendations are scheduled to be completed in a prompt manner.

In addition, the facility is planning to complete several items over the next year to help with their continued effort to provide a safe work environment for Farmer John employees. These changes include the following items:

1. Continue to train all employees in Cal-OSHA's Process Safety Management, EPA's Risk Management Program, and the California Accidental Release Prevention program.
2. Continue to have employee involvement in updating and refining the above mentioned safety programs via the facility's Employee Participation program.
3. Continue internal and external safety audits/inspections and implement changes as needed.